

Date: Monday, 06/10/2008 1:20:26 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET		
Job Number	: 42467					
Estimate Number	: 13062					
P.O. Number				Part Number	: D324511	
This Issue	: 06/10/2008		S.O. No. :	Drawing Number	: D3245 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: B	
Previous Run	: 35665			Material	:	
Written By				Due Date	: 20/10/2008	
Checked & Approved By	: JUL 08.10.06			Qty:	4 Um: Each	
Comment	: Est B 04.12.06 Made in-house KJ/JLM Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	D3245	Gasket			
Comment: Qty.: 0.0460 sf(s)/Unit Total : 0.1840 sf(s)					
GASKET					
Batch: 35607 FB 8-10-14					
2.0	WATER JET	FLOW WATER JET			
Comment: FLOW WATER JET					
1-Cut as per Dwg D3245					
Dwg Rev: B					
Prog Rev: B		FB 8-10-14			
6					
2-Deburr if necessary					
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE					
4.0	QC8	SECOND CHECK			
S 08/10/14 46					
Comment: SECOND CHECK					
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
Comment: PACKAGING RESOURCE #1					
Identify and Stock					
Location: 79		S10/15			
		SP			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 06/10/2008 1:20:26 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 42467

Part Number: D324511

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/15 JG

Job Completion



MUR 08-10-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	13461
Description: Gasket	Part Number:	D3245-11
Inspection Dwg: D3245	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	RB	Audited by:	c	Prototype Approval:	N/A
Date:	8-10-14	Date:	02/10/14	Date:	N/A
Rev	Date	Change		Revised by,	Approved
A	07.11.23	New Issue		KJ/EC/DD	AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

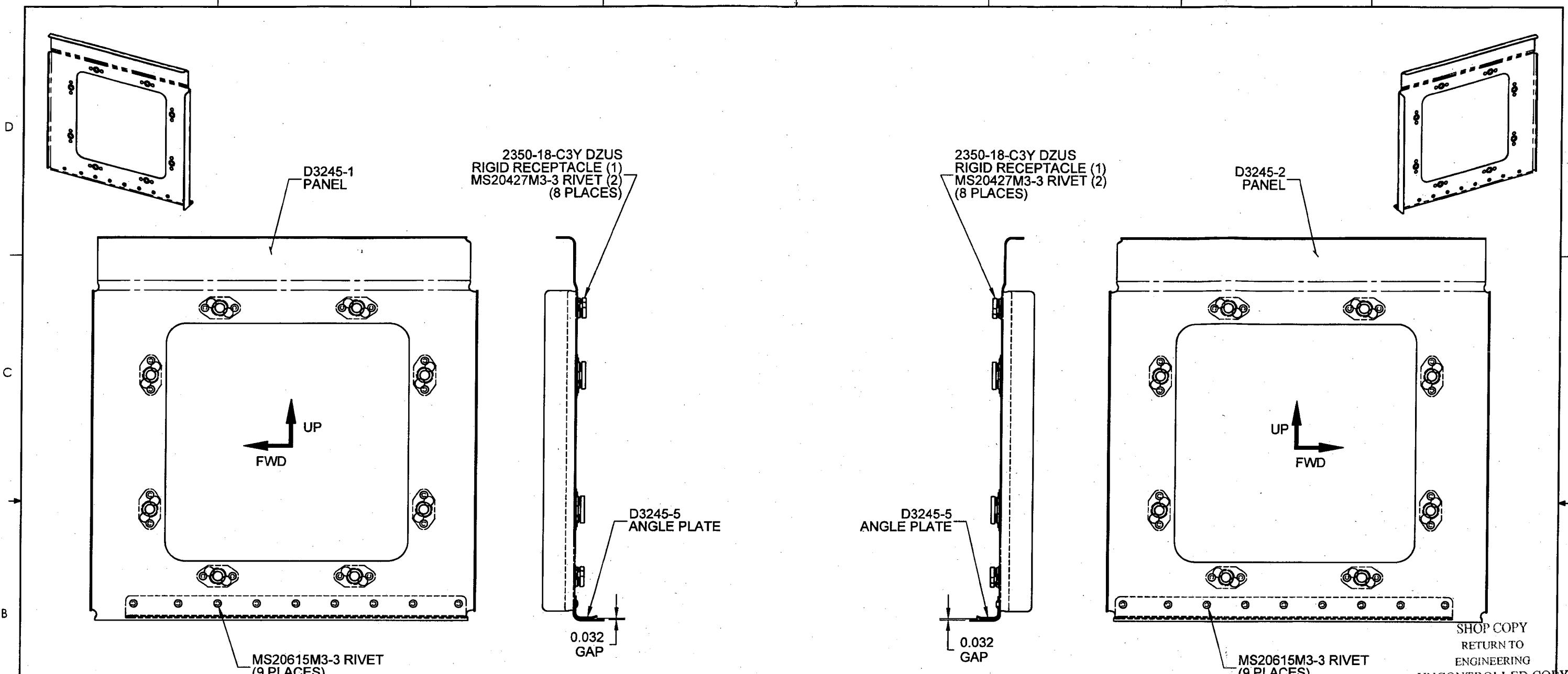
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3245-041	ACCESS PANEL ASSEMBLY, LH
	X	D3245-042	ACCESS PANEL ASSEMBLY, RH
1		D3245-1	PANEL
	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

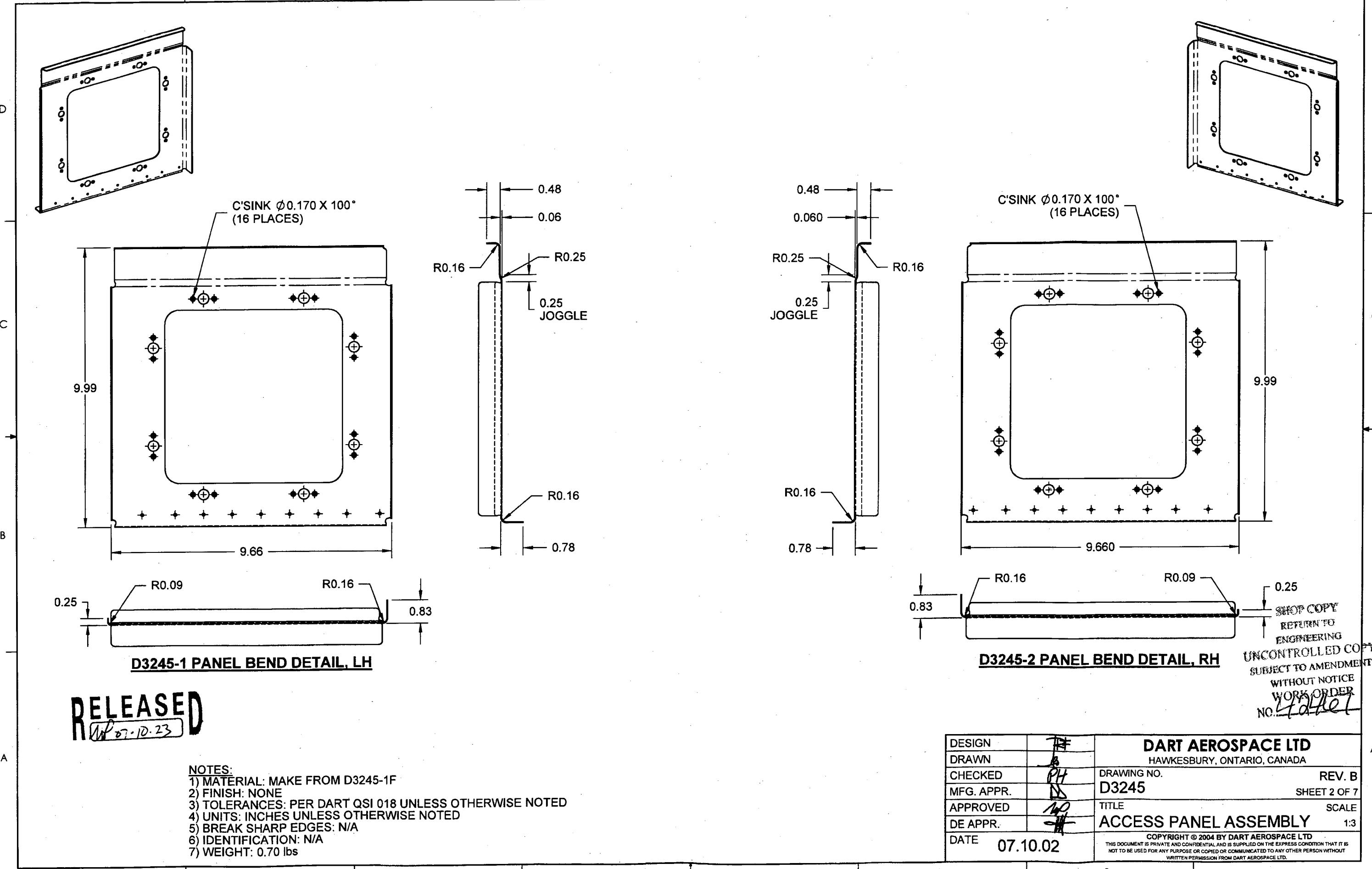
RELEASED
07.10.02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

B	REMOVE Ø0.204 HOLES FROM D3245-1/-1F, REMOVE MS21060-L3K NUTPLATES & DURABLA BLACK GASKETS FROM D3245-041/-042: HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	7F	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	8		
CHECKED	PH		
MFG. APPR.	DS		
APPROVED	MO		
DE APPR.	SH		
DATE	07.10.02	DRAWING NO.	D3245
		REV. B	SHEET 1 OF 7
		TITLE	SCALE
		ACCESS PANEL ASSEMBLY	1:25

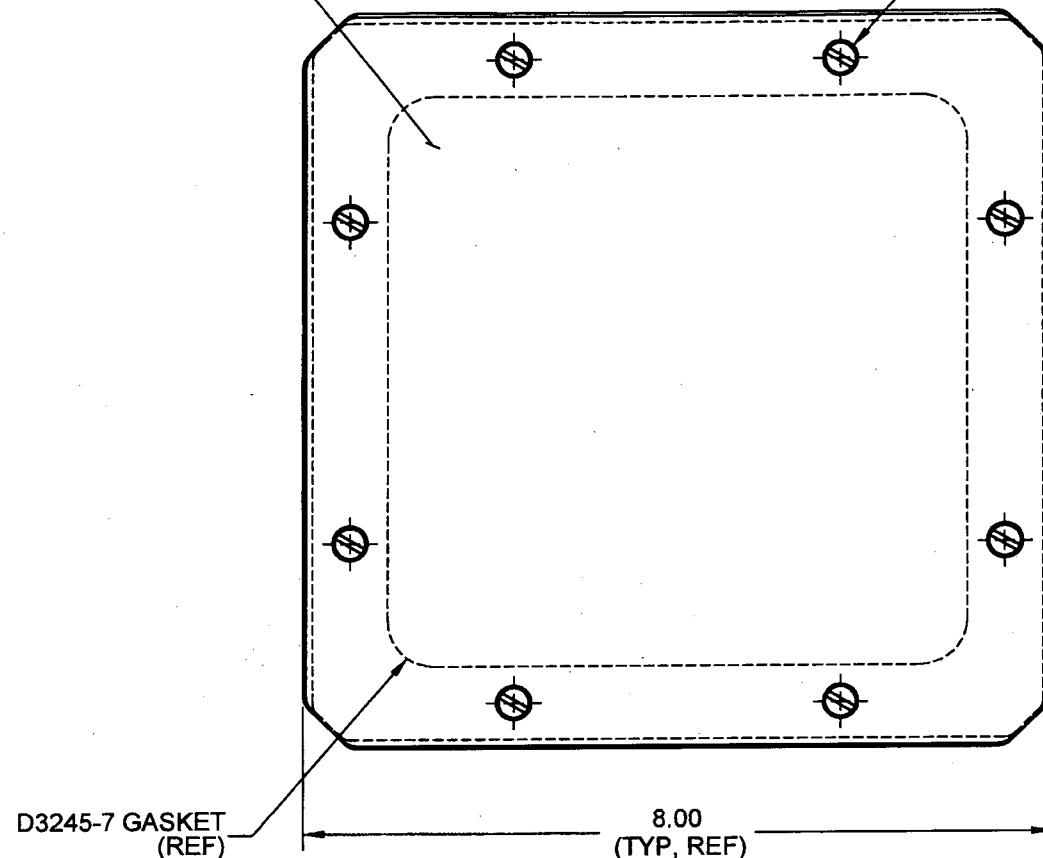
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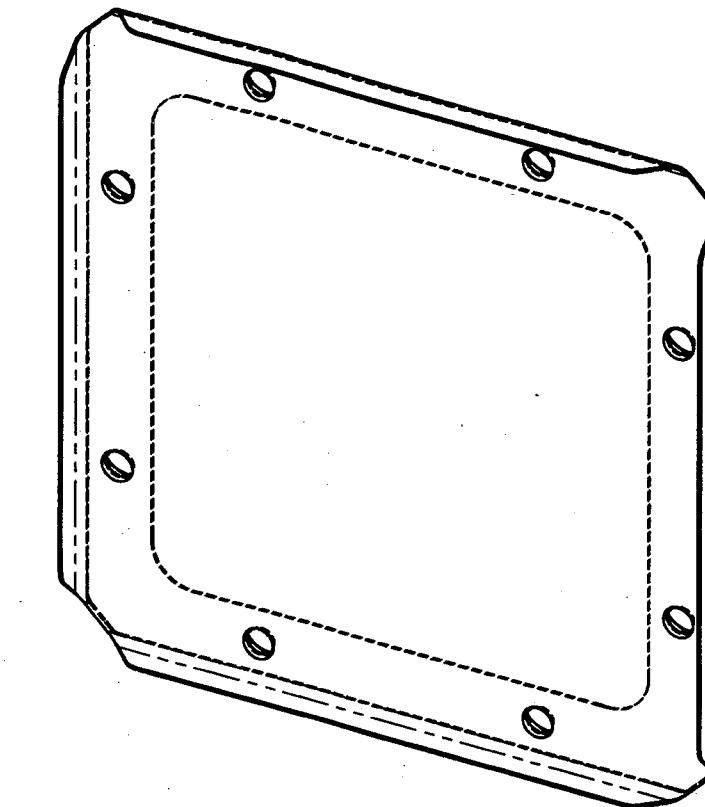
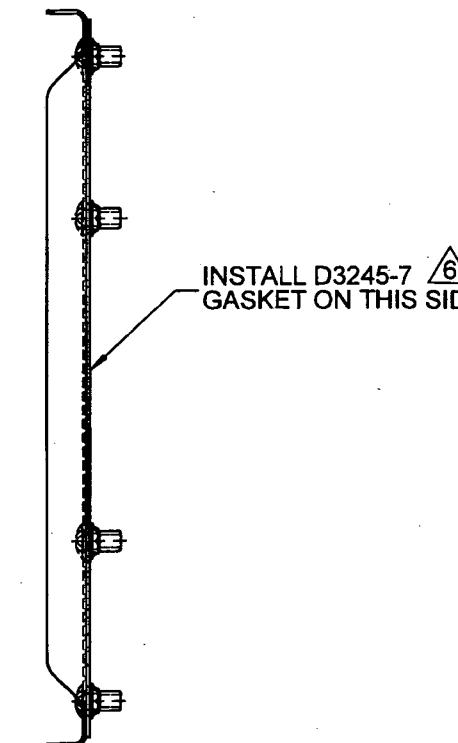
8 7 6 5 4 3 2 1

D3245-5 DOOR

2351-20-009-C3Y STUD (1)
127H-35 GROMMET (1)
(8 PLACES)



D3245-7 GASKET
(REF)



D3245-043 DOOR ASSEMBLY

QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

RELEASED
M 27.10.02

NOTES:

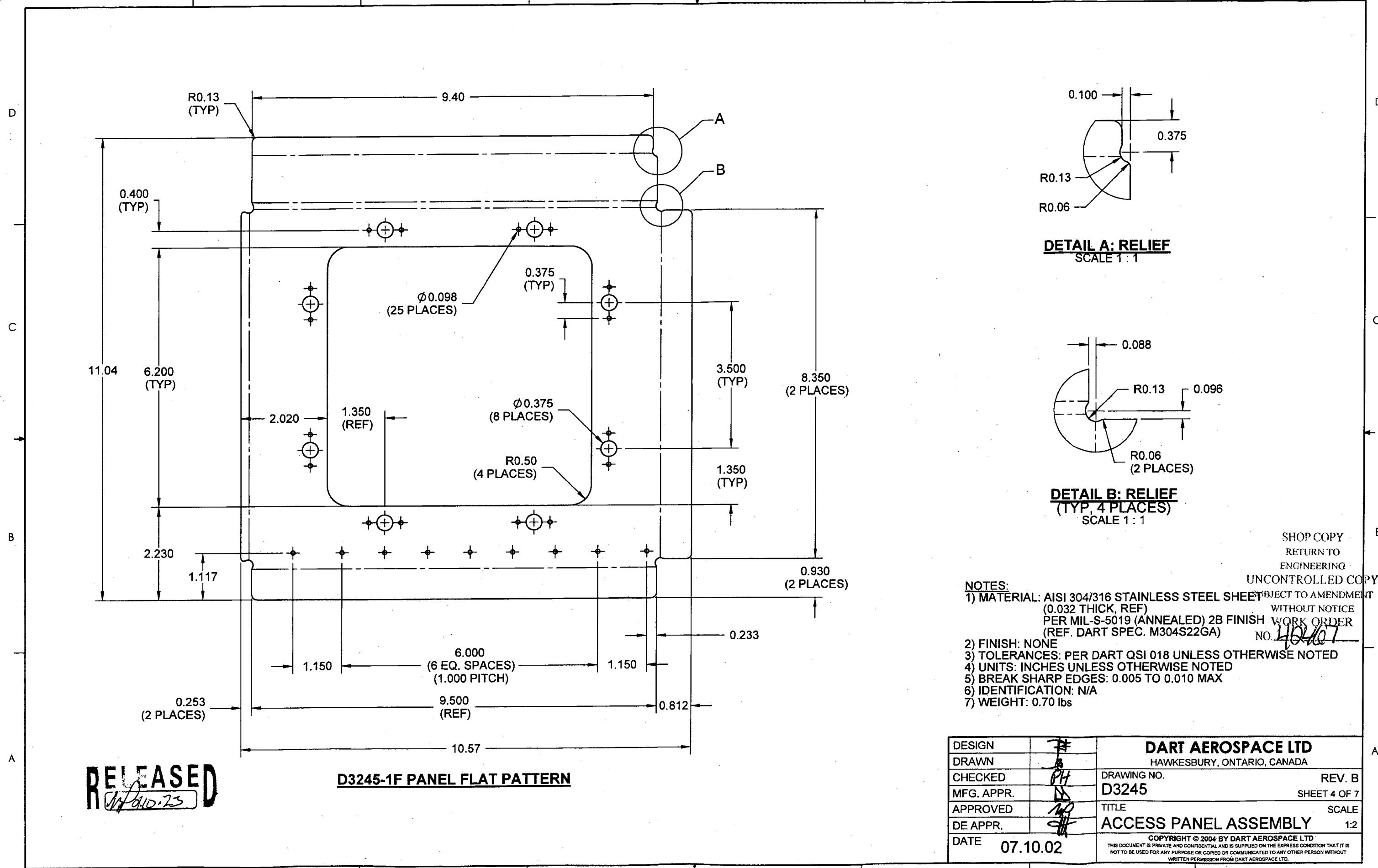
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 9) WEIGHT: 0.73 lbs

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WITHOUT NOTICE
WORK ORDER
NO. 210401

DESIGN	PF	DART AEROSPACE LTD
DRAWN	B	HAWKSLEY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO.
MFG. APPR.	DA	REV. B
APPROVED	MO	D3245
DE APPR.	SH	SHEET 3 OF 7
DATE	07.10.02	TITLE SCALE ACCESS PANEL ASSEMBLY 1:2

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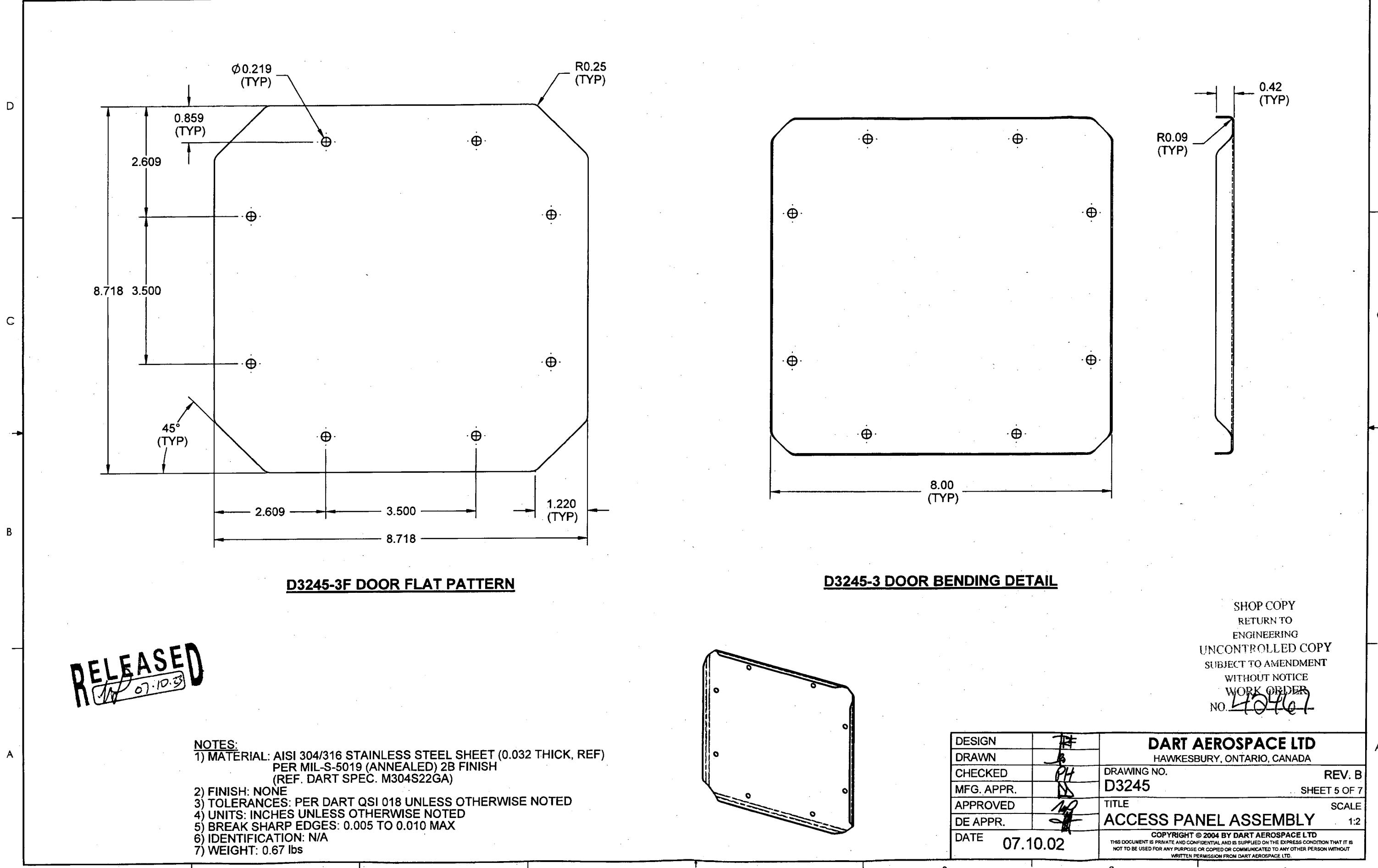
8 7 6 5 4 3 2 1



DESIGN	<i>77</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3245 TITLE ACCESS PANEL ASSEMBLY SCALE 1:2
DRAWN	<i>b</i>	
CHECKED	<i>PH</i>	
MFG. APPR.	<i>DS</i>	
APPROVED	<i>NO</i>	
DE APPR.	<i>SH</i>	
DATE	07.10.02	

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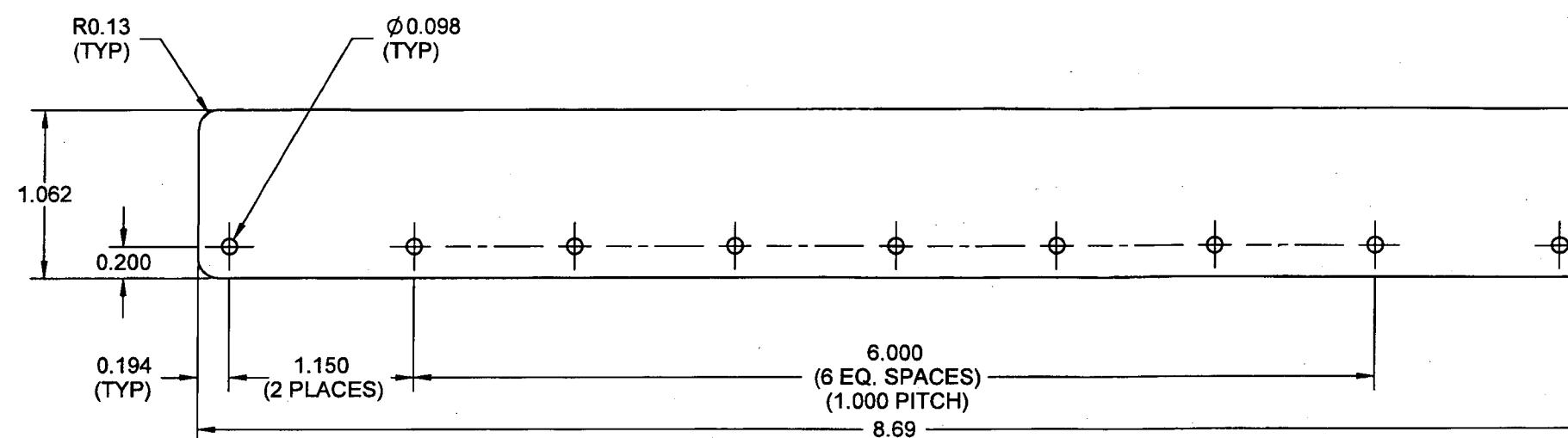
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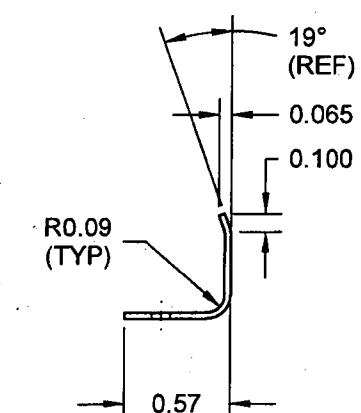
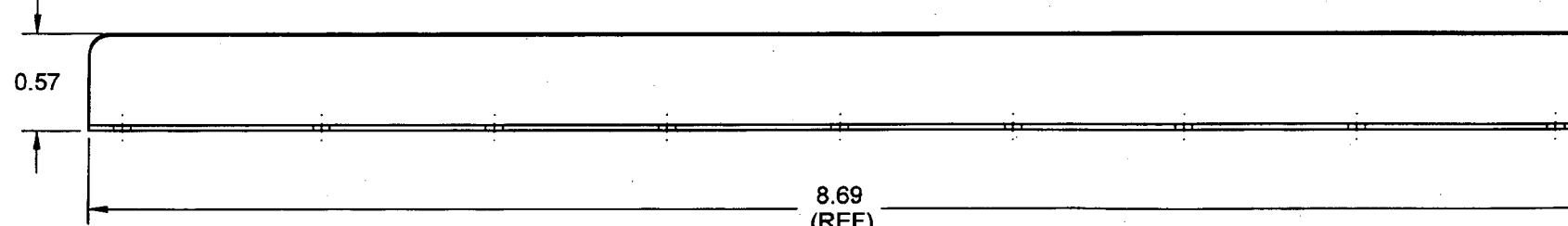
D

D

**D3245-5F FLAT PATTERN**

C

C



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WITHOUT NOTICE
WORK ORDER
NO. 041607

RELEASED
07.10.02

D3245-5 BEND DETAIL
(MAKE FROM D3245-5F)

A

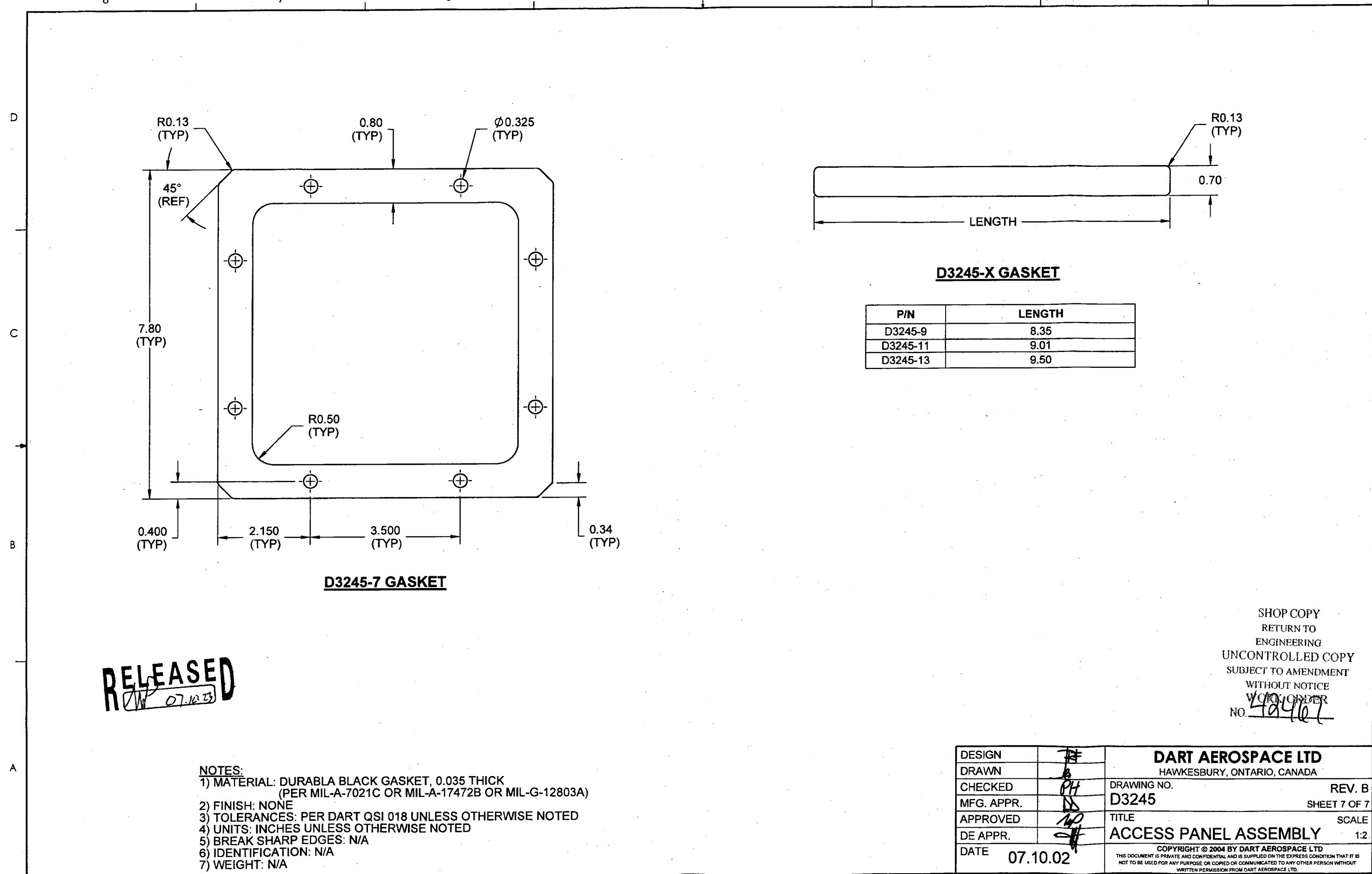
A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)
PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	<i>PF</i>	DART AEROSPACE LTD
DRAWN	<i>B</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO. D3245 REV. B
MFG. APPR.	<i>DA</i>	SHEET 6 OF 7
APPROVED	<i>MP</i>	TITLE
DE APPR.	<i>MM</i>	SCALE 1:1
DATE	07.10.02	ACCESS PANEL ASSEMBLY
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8 7 6 5 4 3 2 1



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CHECKED	<i>PH</i>	DRAWING NO.	
MFG. APPR.	<i>DS</i>	REV. B	
APPROVED	<i>MO</i>	D3245	
DE APPR.	<i>CH</i>	SHEET 7 OF 7	
DATE	07.10.02	TITLE	
		SCALE	
		1:2	
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